

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004370**Date Inspected:** 13-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jeff Chan, CK Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Heavy Shop 1**Ultrasonic Testing**

The Quality Assurance Inspector performed 25% random ultrasonic testing verification on skin plate welds. The Quality Assurance Inspector performed the testing on the following welds; SSD1 SA164 D/F 7B, SSD1 SA164 D/F 23B, SSD1 SA164 D/F 38B, SSD1 SA164 D/F 12B, SSD1 SA164 D/F 8B, SSD1 SA164 E/F 7 A/B, SSD1 SA164 E/F 8 A/B, SSD1 SA164 E/F 10A/B, SSD1 SA164 E/F 23A/B, SSD1 SA164 E/F 24A/B, SSD1 SA164 E/F 30A/B, and SSD1 SA171 D 19A/B. See Caltrans report TL-6027 Ultrasonic Testing Report, dated October 13, 2008 for additional information.

In process of performing fit up operations on Skin A South Tower to diaphragms.

In process of repairing visual indication discovered by ZPMC and AB/F Quality Control Inspectors on longitudinal stiffener to skin plate C South Tower with the use of SMAW welding process. (Undercut and under fill).

Quality Assurance Inspector verified connection plates to longitudinal stiffeners fit up at the bevel to be 43 to 45 degrees and less than 1 mm at the root gap.

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Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara,Raymond	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
